

Work Order ID 147153

Friday, June 03, 2016 11:43:34 AM

147153

Page 1

Item ID: D350-588-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Door Assembly

Start Date: 6/3/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/24/2016 Req'd Qty: 1.00

1

Customer:

Reference: Rework per NCR 16-5766

Approvals: Process Plan: Rem Date: 16/06/03 Tooling:

Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2445/D350-588	Rev D/D								
DSI9690	A								

190

0.00

190

QC

Quality Control

Memo

0.00

PULL FROM STOCK D350-588-041 X 1 B141777

WAS FOUND THE DOORS WERE IN BAD SHAPE, RETURN TO SUPPLIER
AS PER NCR 16-5766 FOR EVALUATION AND REWORKDAS
27
9-89

JUL 18 2016

200

0.00

200

Purchasing

Purchasing

Memo

Issue P/O:

Description: D2445 Baggage Door

Supplier: FDC composite

Ship to supplier (1) D0588-041 label

Certification of Conformity and process sheet is required.

****REWORK****

DOOR SHOULD BE RETURNED ASSEMBLED PER QC

DAS
13
9-89

JUL 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								

DQA:

Date: 16.08.09



QA Closed:

Date: 14/07/20

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: 147153		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. D30-S88-04 re-opened for ADD		Rework ☒		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. 16-5914		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☒		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date: 16.07.15		Step #: 190		QTY Effective: ①				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				PD 16-07-14	
two lock nuts were missing from				Replace with D3015 B144165 2x				Completed By	
P.C. Handling								PD 16-07-14	
Ref to WCRB-5914 in Q Pulse								Lead hand / Supervisor Approval Verification	
								PD 16-07-14	
								QC / QA Coordinator Approval	
								PD 16-07-14	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☒	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☒				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Work Order ID 147153

Friday, June 03, 2016 11:43:34 AM

147153

Page 3

Item ID: D350-588-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Door Assembly

Start Date: 6/3/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/24/2016 Req'd Qty: 1.00

1

Customer:

Reference: Rework per NCR 16-5766

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

Identify as per dwg & Stock Location: _____

0.00

240

Packaging

Memo

*Repackaging using
original B/N
fs D21*

0.00

DAS
27
9-89

JUL 18 2016

250

QC21- Final Inspection - Work Order Release

0.00

250

QC

Memo

0.00

DAS
21
9-89

JUL 19 2016

Quality Control

DAS
21
9-89

JUL 19 2016

NOT AT

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

Picklist Print

Page 1

Friday, June 03, 2016 11:43:34 AM

Work Order ID: 147153

147153

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 6/3/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP P 04.02.04ReformatKJ/DS IPP Rev:Q as
per DSI9414 DD verified by:EC IPP Rev:R add pick kit DD
10.03.29 verified by:EC IPP REV:S 14.04.28 AS PER
DSI9690 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-588-041		Manufactured	No				Each	0.0000		1			

D350-588-041

Aft Door Assembly

BK1777 dm 16/06/03

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

List Lots

Page 1 of 1

Thursday, June 02, 2016 1:50:44 PM

Criteria : Item ID: D350-588-041 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
D350-588-041 Aft Door Assembly	Quarantine QC	140737	6/2/2016	1.0000	QC21	CHG003	
	Quarantine QC	141774	6/2/2016	1.0000	QC21	CHG003	
	Quarantine QC	141775	6/2/2016	1.0000	QC21	CHG003	
	Quarantine QC	(141777) 147153	6/2/2016	1.0000	QC21	CHG003	
	Total:			4.0000			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							



Non-Conformance Report

Reviewed
DQA:
Date:

Printed on: Thursday, June 02, 2016

Details			
Raised Date 5/9/2016	Status Open	Owner Smith, Patrick	Number NCR16-5766
Target Date 7/1/2016	Standard		Severity MINOR
Process		Audit	
Raised By Person Air Medical Resources		Raised Against (Department or Supplier)	Fault Category
Details			
Mike DiDomenico received information during a site visit. Recently purchased Qty7 D350-588-041 Doors. Reports door is effected. Bad shape and label and seal is coming off. See pictures attached#2 Report from Air Commander Aerospace - SO126398/INV128640/D350-588-041 B141776			
Keywords Case9375/9404		Product D350-588/D350-588-041	
Document		Root Cause	
Closed By	Closed Date	Resolution	

Corrective Action			
Target Date 6/24/2016	Owner Smith, Patrick	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
1	Smith, Patrick	5/10/2016	
Check stock, fit check			
2	Renwick, Jennifer	5/11/2016	5/11/2016
Contact customer- get amount confirmation and batches.		See case 9375	
3	Smith, Patrick	5/10/2016	5/10/2016
Have we changed vendor/process recently			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐						
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY								
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

4	Renwick, Jennifer	5/10/2016	5/11/2016
How did the seals come off? Issue no charge replacements for qty6 seals (D2463-0870)		Customer confirmed seals came off due to poor packaging - Bubble wrap was stuck underneath seal Issued SO126235	
5	Renwick, Jennifer	5/24/2016	5/31/2016
#2 Affected customer - Issue no charge		Issued SO126542	
6	Renwick, Jennifer	5/31/2016	5/31/2016
#2 Affected Customer - Issue RA		Issued RA112326	
7	Renwick, Jennifer	5/31/2016	5/31/2016
Find out batch cut off when FDC started producing kits		B139280	
8	Downing, Eric M	6/3/2016	
pull all doors fabricated by FDC and return them to be reworked. record B#'s			
9	Lacelle, Linda	6/2/2016	
create work order to perform reworking			

Target Date 6/24/2016	Owner Downing, Eric M	Closed Date	Closed By
Details			

Number	Owner	Target Date	Completed Date
Details		Response	

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32641**

Purchase Order Date 6/8/2016

PO Print Date 7/14/2016

Page Number 1 of 2

Order From : VC-FDC01
FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name
Vendor Phone 450-357-1344 ext303

Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	147153	D350-588-041 AFT DOOR	7/14/2016 Yes 7/14/2016		1.00	\$196.67	\$196.67
	NCR16-5766 RE-WORK, LABEL & SEAL COMING OFF						
						Line Total:	\$196.67
2	147151	D350-588-041 AFT DOOR	7/14/2016 Yes 7/14/2016		1.00	\$196.67	\$196.67
	NCR16-5766 RE-WORK, LABEL & SEAL COMING OFF						
						Line Total:	\$196.67
3	147152	D350-588-041 AFT DOOR	7/14/2016 Yes 7/14/2016		1.00	\$196.67	\$196.67
	NCR16-5766 RE-WORK, LABEL & SEAL COMING OFF						

Note:

7/14/2016

FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5 **Tel. : 450 357-1344**

Shipping Order

06/07/2016

Order : 2493
Reference : PO #32819/1

Customer: Dart

DART AEROSPACE Ltd.
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Ship To
DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7 **Tel. : 1 613 632-9577**

Item No.	Description	Qty	Qty. Delivere	B/O Qty
71875-65	Repair, Destruction & Manufacturing of D2445 Side Door PO item: 32819/1 Lot: 2016-02-22, B141774 2016-02-24, B141775 2016-02-26, B141777	1	_____	_____
71401-45	Procurement Quality Clauses	1	_____	_____

SP/6-7-13.

Shipping : _____

Package No : _____

Merchandise Received: _____

Ref. : _____



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CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

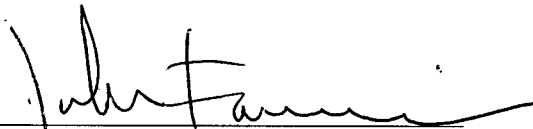
Customer P/O Number: 32819

Certificate Revision : NC

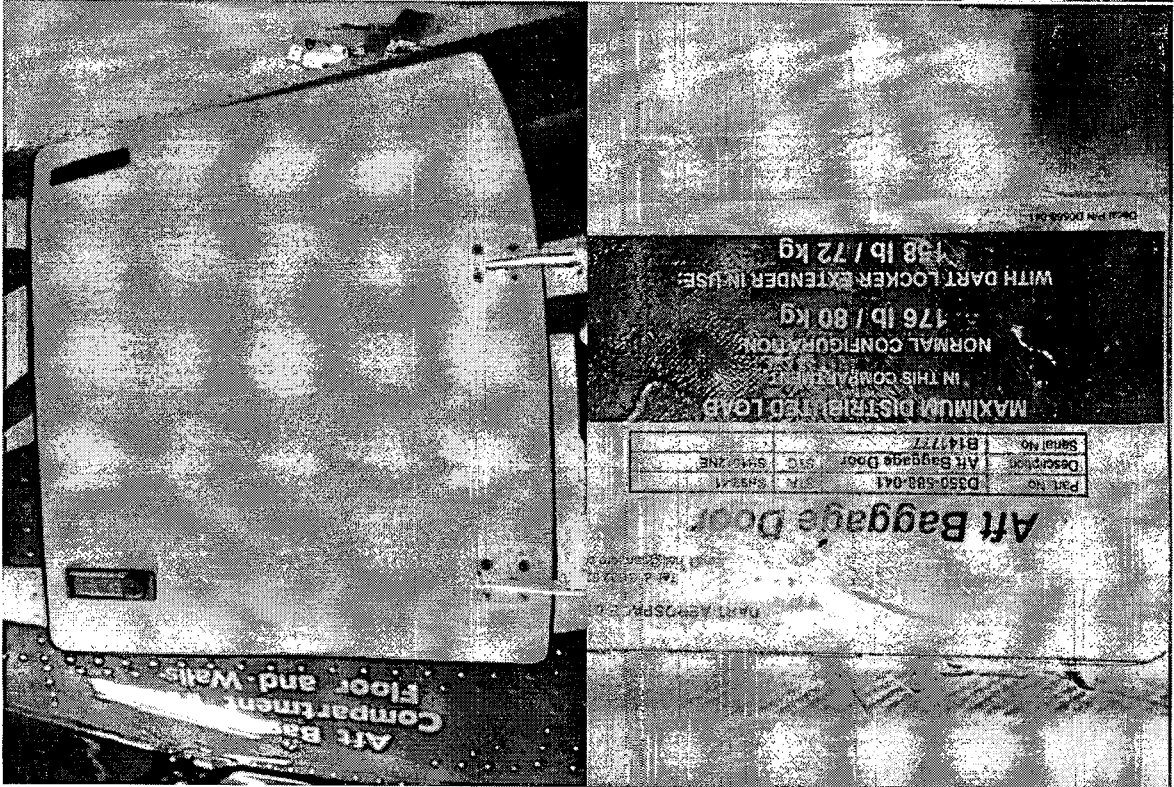
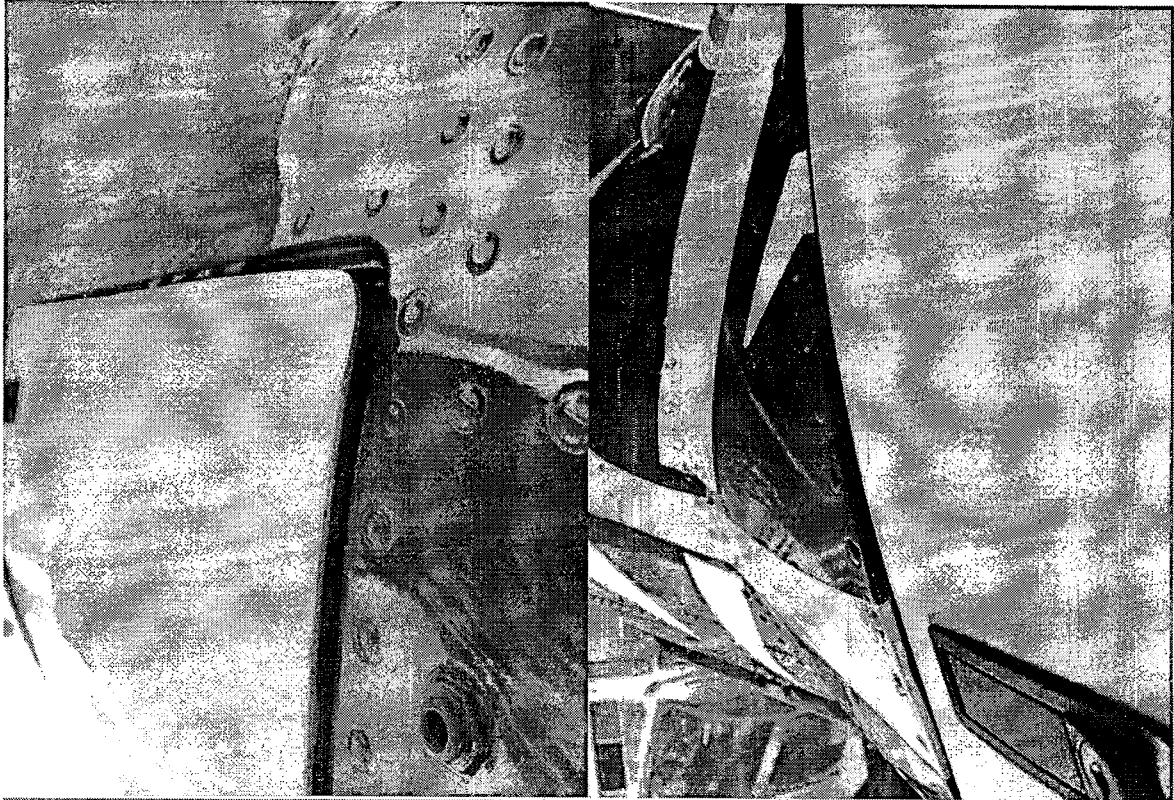
<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Drawing number</u>	<u>Description</u>	<u>FDC Serial</u>	<u>Lot</u>
1	3	D2445P	D2445 Rev D	Aft Door Assembly B141774 Aft Door Assembly B141775 Aft Door Assembly B141777	DAE007-012 DAE007-011 DAE007-013 ✓	2016-02-22 2016-02-24 2016-02-26

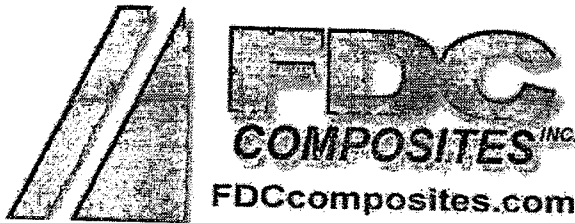
NOTE: Part repaired as per Dart's quality department requirements (Parts shape corrected by thermoforming in a conformer).

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature: 
Jules Fournier, BDI, Quality Manager

Date: 2016-07-06





Thursday, June 23rd, 2016 (By Email)

Quote #: 1331

Attention: Linda Lacelle, Purchasing Manager
Dart Aerospace Inc.
1270 Aberdeen St, Hawkesbury, Ontario, K6A 1K7
llacelle@dartaero.com

Subject: Price Proposal – Repair, Destruction & Manufacturing of D2445 Side Doors

References:

- A. Official RFQ information received after visit of Eric Downing at our facility on June 14th, 2016.

Dear Mme Lacelle,

Here's our price proposal for the repair, destruction and manufacturing of D2445 side door for quality comparison analysis.

GENERAL ASSUMPTIONS

- 1- Prices are based on the drawings and specifications received at references.
- 2- All prices are in Canadian dollars (CAD), FOB our plant.
- 3- Packaging cost is included in the prices.
- 4- Parts manufacturing process will be Wet Lay-Up/Bagging and/or Resin Infusion.
- 5- All parts will be manufactured per DART Aerospace specification documents.
- 6- No post-curing is included.
- 7- Surface finish of each assembly (ex: priming and painting) is included and will be made according to DART Aerospace specifications.
- 8- Drilling of holes in the part is included.
- 9- Other specific technical requirements not described in the RFQ documents and in this proposal are not included and will need to be discussed.

1- PRICE PROPOSAL

a) Unit Price – Spacepod Parts

In this section, you will find the unit price for the repair, destruction and manufacturing of your D2445 side doors for quality analysis comparison.

Item	Description	Total Price
Repair. Destruction & Manufacturing of D2445 Side Doors	1. Repair of one (1) D2445 side door. 2. Destruction of a Delastek D2445 door for analysis. 3. Manufacturing of one (1) D2245 side door for destruction and analysis. 4. Manufacturing of one (1) D2445 side door as a sample with different size core.	\$ 1,920
Total		\$ 1,920

2- COMMERCIAL & CONTRACTUAL CONSIDERATIONS

a) Payment Terms

Payment terms are the following:

Item	Note
All orders	Net 30 days

b) Lead Time

Lead time for the parts is the following:

Item	Note
All orders	2 weeks

c) Limited Warranty

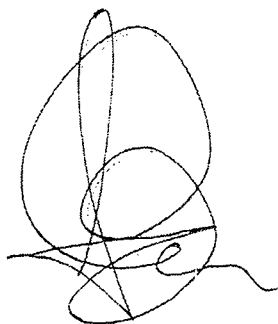
FDC Composites Inc. warrants that the product(s) was/were manufactured in accordance with the specifications provided by the client. This warranty is limited to the value of the product(s) or replacement(s), as applicable. By the same token, the client explicitly exempts FDC Composites Inc. of responsibility concerning the product performance, except as expressly described by the Purchase Order. This disclaimer includes all damages of any nature whatsoever arising from use of the product(s) by the client or a third party. This limited warranty is valid for a period of twelve (12) months from the date of delivery of the product.

d) Proposal Validity

This quote is valid for thirty (30) days. The lead times and prices may vary after that period. Note that any change to the above stated documents and assumptions may have an effect on the unit price and tooling price.

Thank you for choosing FDC Composites Inc. This proposal has been carefully prepared and we are more than confident that we have the capability to manufacture the parts that are parts described above.

Best regards,

A handwritten signature in black ink, consisting of several overlapping loops and a long horizontal stroke at the bottom.

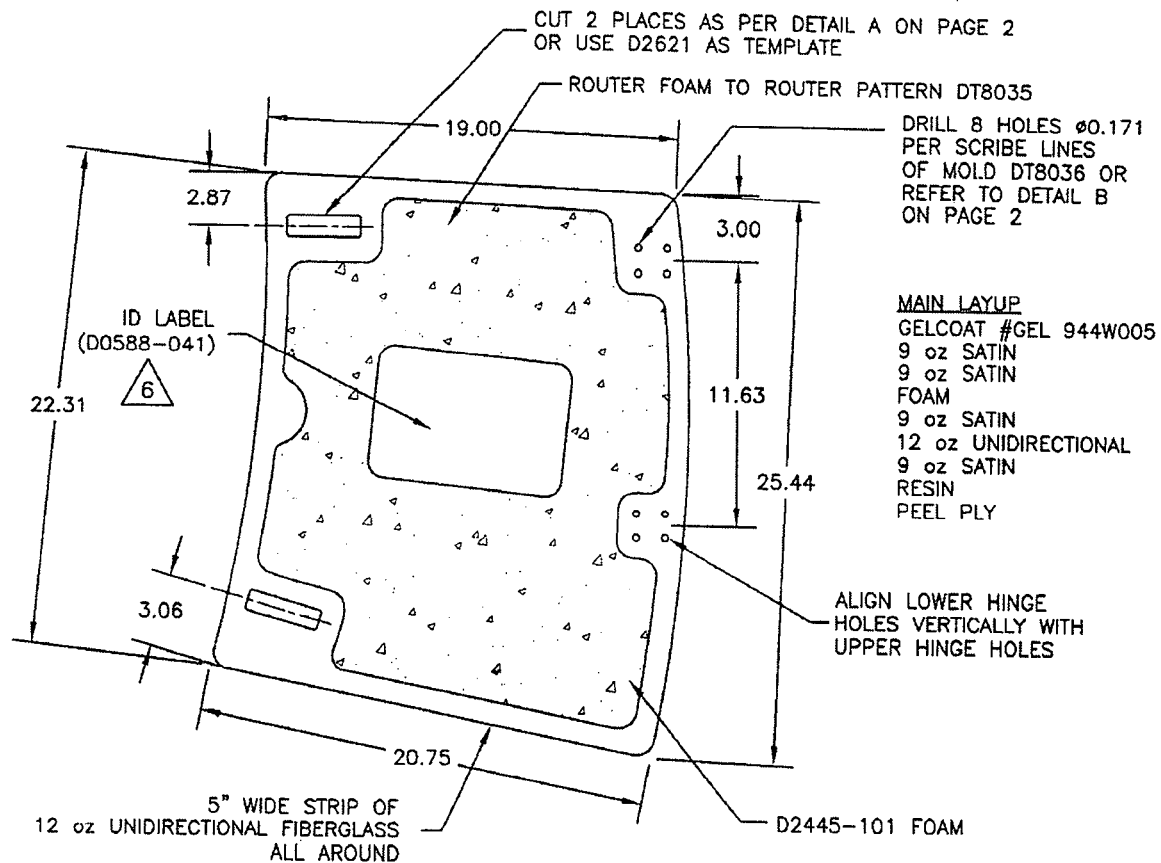
Jacques Cabana
President & General Manager

c.c.:

Stéphane Pageau, Chief Technician
Carl Béliveau, Vice-President & Operations Manager

Drawing of parts to be manufactured:

Side Door - D2445





Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32819**

Purchase Order Date 6/24/2016

PO Print Date 7/18/2016

Page Number 1 of 2

Order From :

VC-FDC01

FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450-357-1344 ext303

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	71875-65	REPAIR, DESTRUCTION & MANUFACTURING OF D2445 SIDE DOOR	7/14/2016		1.00	\$1,920.00	\$1,920.00
	QUOTE #: 1331		Yes 7/14/2016		Each		
Line Total:							\$1,920.00
2	71401-45	PROCUREMENT QUALITY CLAUSES	7/14/2016		1.00	\$0.00	\$0.00
	Procurement Quality Clauses		No 7/14/2016				
	A004 faa-pma/tso						
	A005 right of entry						
	A016 personnel qualification						
	A025 certification of conformance						
	A040 notification of quality escape						
	A041 quality management						
	A042 dart noyification by supplier						
	A043 retention of quality documents						

Note:

7/18/2016



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32819**

Purchase Order Date 6/24/2016

PO Print Date 7/18/2016

Page Number 2 of 2

Order From :

VC-FDC01

FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450-357-1344 ext303

Ship To Contact

Ship To Phone

Ship Via: —

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB Destination-Collect

Line Total: \$0.00

PO Total: \$1,920.00

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 2

Change Date: 7/18/2016



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32641**

Purchase Order Date 6/8/2016
PO Print Date 7/18/2016

Page Number 1 of 2

Order From :

VC-FDC01

Ship To : DART AEROSPACE LTD

FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450-357-1344 ext303

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Ship To Contact

Terms Net 30

Ship To Phone

Currency CAD

Ship Via:

FedEx Overnight collect

FOB

Destination-Collect

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	147153	D350-588-041 AFT DOOR	7/14/2016 Yes 7/14/2016		1.00	\$196.67	\$196.67
	NCR16-5766 RE-WORK, LABEL & SEAL COMING OFF						
Line Total:							\$196.67
2	147151	D350-588-041 AFT DOOR	7/14/2016 Yes 7/14/2016		1.00	\$196.67	\$196.67
	NCR16-5766 RE-WORK, LABEL & SEAL COMING OFF						
Line Total:							\$196.67
3	147152	D350-588-041 AFT DOOR	7/14/2016 Yes 7/14/2016		1.00	\$196.67	\$196.67
	NCR16-5766 RE-WORK, LABEL & SEAL COMING OFF						

Note:

7/18/2016



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32641**

Purchase Order Date 6/8/2016

PO Print Date 7/18/2016

Page Number 2 of 2

Order From :

VC-FDC01

FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450-357-1344 ext303

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Total: \$196.67

4	71401-45	PROCUREMENT QUALITY CLAUSES	7/14/2016	1.00	\$0.00	\$0.00
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No

Procurement Quality Clauses
A004 faa-pma/tso
A005 right of entry
A016 personnel qualification
A025 certification of conformance
A040 notification of quality escape
A041 quality management
A042 dart notification by supplier
A043 retention of quality documents

7/14/2016

Line Total: \$0.00

5	147150	D350-588-041 AFT DOOR	7/15/2016	1.00	\$196.67	\$196.67
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Yes

7/15/2016

NCR16-5766 RE-WORK,
LABEL & SEAL COMING OFF

Line Total: \$196.67

PO Total: \$786.67

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 6

Change Date: 7/18/2016